

Date: Thursday, 7/20/2006 1:05:43 PM  
 User: Linda Lacelle

## Process Sheet

Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name:	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number:	27992	Part Number:	D2571		
Estimate Number:	10530	Drawing Number:	D2571 REV E		
P.O. Number:	N/A	Project Number:	N/A		
This Issue:	7/20/2006	S.O. No.:	N/A		
Prsht Rev.:	NC	Drawing Revision:	E		
First Issue:	7/20/2006	Type:	MACHINED PARTS		
Previous Run:	27887	Material:	N/A		
Written By:		Due Date:	8/5/2006		
Checked & Approved By:	06.07.21	Qty:	24		
Comment:	Est: 106.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>823941 x 23</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>827992</u> Double check by: <u>36</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: *[Signature]*Date: *06/08/30*

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Thursday, 7/20/2006 1:05:44 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number: 27992		Part Number: D2571
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8 	SECOND CHECK 
Comment: SECOND CHECK		J.L. 06/08/24
6.0	HAND FINISHING 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		a.m. 06-08-26 (24)
7.0	POWDER COATING 	POWDER COATING 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		a.m. 06-08-28 (24)
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		10/08/28 (24)
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: STY79		10/08/28 (24)
10.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		10/08/28 (24)
Job Completion 		10/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD				Work Order:	27992
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	0.440	0.440	0.440		
B	1.745	1.755		1.746	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.497	3.496		
D	1.745	1.755		1.746	1.747	1.747	1.746		
E	7.990	8.010		8.002	8.000	8.001	8.002		
F	0.490	0.510		0.496	0.497	0.496	0.497		
G	0.257	0.262	DT8683	✓	0.258	0.258	0.258		
H	0.375	0.380	DT8684	✓	0.376	0.376	0.376		
I	0.490	0.510		0.496	0.497	0.498	0.497		
J	1.174	1.184		1.175	1.179	1.179	1.179		
K	0.558	0.578		0.558	0.568	0.569	0.568		
L	1.174	1.184		1.175	1.177	1.178	1.179		
M	1.490	1.500		1.492	1.497	1.496	1.497		
N	2.495	2.505		2.498	2.497	2.497	2.498		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		0.127	0.126	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.254	0.249		
S	0.115	0.135		0.125	0.124	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.960	2.960	2.961		
V	0.230	0.250		0.242	0.247	0.246	0.246		
W	0.115	0.135		0.116	0.117	0.117	0.118		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.363	0.363	0.364	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.620	0.621	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.246		
AE	1.375	1.395		1.385	1.384	1.384	1.389		
AF	0.115	0.135	x	0.135	0.135	0.135	0.135		
AG	0.240	0.280	x	0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.254	0.253	0.252		
AI	2.000	2.020		2.000	2.000	2.001	2.002		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN/3.G	Audited by:	JKL
Date:	06/08/17	Date:	06/08/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JKL

DART AEROSPACE LTD				Work Order:	27992
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 8		
A	0.438	0.443	DT8682	✓	✓	✓	—		
B	1.745	1.755		1.747	1.747	1.751	1.750		
C	3.495	3.505		3.497	3.497	3.499	3.499		
D	1.745	1.755		1.747	1.746	1.751	1.750		
E	7.990	8.010		8.001	8.000	8.001	8.002		
F	0.490	0.510		0.499	0.497	0.498	0.499		
G	0.257	0.262	DT8683	✓	✓	✓	—		
H	0.375	0.380	DT8684	✓	✓	—	—		
I	0.490	0.510		0.500	0.500	0.498	0.493		
J	1.174	1.184		1.179	1.177	1.178	1.175		
K	0.558	0.578		0.568	0.566	0.563	0.563		
L	1.174	1.184		1.179	1.177	1.178	1.175		
M	1.490	1.500		1.499	1.497	1.495	1.495		
N	2.495	2.505		2.499	2.497	2.499	2.498		
O	3.869	3.879		3.871	3.870	3.872	3.873		
P	0.115	0.135		0.124	0.124	0.125	0.126		
Q	0.115	0.135		0.127	0.126	0.135	0.135		
R	0.240	0.260		0.251	0.249	0.252	0.251		
S	0.115	0.135		0.127	0.126	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.236	0.237	0.234	0.234		
W	0.115	0.135		0.119	0.118	0.119	0.119		
X	0.308	0.313		0.311	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.361	0.371	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.621	0.622	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.244	0.245		
AE	1.375	1.395		1.387	1.384	1.384	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.247	0.246	0.260	0.266		
AH	0.240	0.260		0.250	0.250	0.246	0.246		
AI	2.000	2.020		2.001	2.003	2.003	2.004		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	J.G / -EP	Audited by:	J.L
Date:	06/08/18	Date:	06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	✓ ✓

DART AEROSPACE LTD				Work Order:	27992
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 R		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.750	1.747	1.745	1.748		
C	3.495	3.505		3.499	3.500	3.499	3.498		
D	1.745	1.755		1.750	1.747	1.745	1.748		
E	7.990	8.010		8.001	8.002	8.001	8.002		
F	0.490	0.510		0.496	0.497	0.496	0.498		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.496	0.494	0.495	0.498		
J	1.174	1.184		1.177	1.176	1.178	1.175		
K	0.558	0.578		0.562	0.560	0.561	0.563		
L	1.174	1.184		1.177	1.176	1.178	1.175		
M	1.490	1.500		1.493	1.493	1.495	1.495		
N	2.495	2.505		2.499	2.498	2.498	2.496		
O	3.869	3.879		3.872	3.872	3.872	3.869		
P	0.115	0.135		0.123	0.126	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.252	0.251	0.250		
S	0.115	0.135		0.121	0.123	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.233	0.235	0.233	0.232		
W	0.115	0.135		0.119	0.119	0.120	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.360	0.361	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.624	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.244	0.247	0.244		
AE	1.375	1.395		1.386	1.384	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.268	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.249	0.250	0.247		
AI	2.000	2.020		2.001	2.000	2.001	2.001		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN B	Audited by:	GRJ
Date:	06/08/21	Date:	06/08/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	GRJ

DART AEROSPACE LTD				Work Order:	27992
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.745	1.746	1.747	1.747		
C	3.495	3.505		3.497	3.496	3.500	3.499		
D	1.745	1.755		1.745	1.746	1.746	1.746		
E	7.990	8.010		8.001	8.000	8.000	8.001		
F	0.490	0.510		0.497	0.496	0.498	0.497		
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.495	0.495	0.496	0.497		
J	1.174	1.184		1.177	1.176	1.178	1.179		
K	0.558	0.578		0.566	0.566	0.567	0.566		
L	1.174	1.184		1.177	1.176	1.178	1.178		
M	1.490	1.500		1.492	1.493	1.494	1.493		
N	2.495	2.505		2.499	2.497	2.496	2.497		
O	3.869	3.879		3.871	3.872	3.871	3.871		
P	0.115	0.135		0.125	0.124	0.123	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.250	0.249	0.248		
S	0.115	0.135		0.124	0.124	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.234	0.235	0.234		
W	0.115	0.135		0.120	0.121	0.122	0.124		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.367	0.367	0.367		
AA	0.470	0.530		0.560	0.560	0.560	0.560		
AB	0.615	0.635		0.623	0.624	0.624	0.624		
AC	0.053	0.073		0.063	0.062	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.251	0.251		
AE	1.375	1.395		1.387	1.380	1.390	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.251	0.251	0.252		
AI	2.000	2.020		2.002	2.002	2.004	2.004		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	CP / J.G	Audited by:	J.J
Date:	06/08/24	Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JUL

DART AEROSPACE LTD				Work Order:	27992
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

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C	3.495	3.505		3.499	3.499	3.501	3.497		
D	1.745	1.755		1.747	1.747	1.747	1.745		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		0.491	0.491	0.492	0.493		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.498	0.497	0.497	0.495		
J	1.174	1.184		1.180	1.180	1.178	1.179		
K	0.558	0.578		0.567	0.568	0.567	0.568		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.498	1.495	1.494	1.492		
N	2.495	2.505		2.500	2.494	2.497	2.499		
O	3.869	3.879		3.871	3.872	3.871	3.870		
P	0.115	0.135		0.134	0.133	0.134	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.252	0.251	0.252		
S	0.115	0.135		0.124	0.125	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.961	2.961	2.960		
V	0.230	0.250		0.241	0.242	0.241	0.236		
W	0.115	0.135		0.135	0.134	0.133	0.119		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.371	0.363	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.624	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.251	0.256		
AE	1.375	1.395		1.387	1.388	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.266	0.266	0.266	0.266		
AH	0.240	0.260		0.255	0.255	0.255	0.247		
AI	2.000	2.020		2.004	2.004	2.003	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	5. G	Audited by:	J.L
Date:	06/08/23	Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SPJ

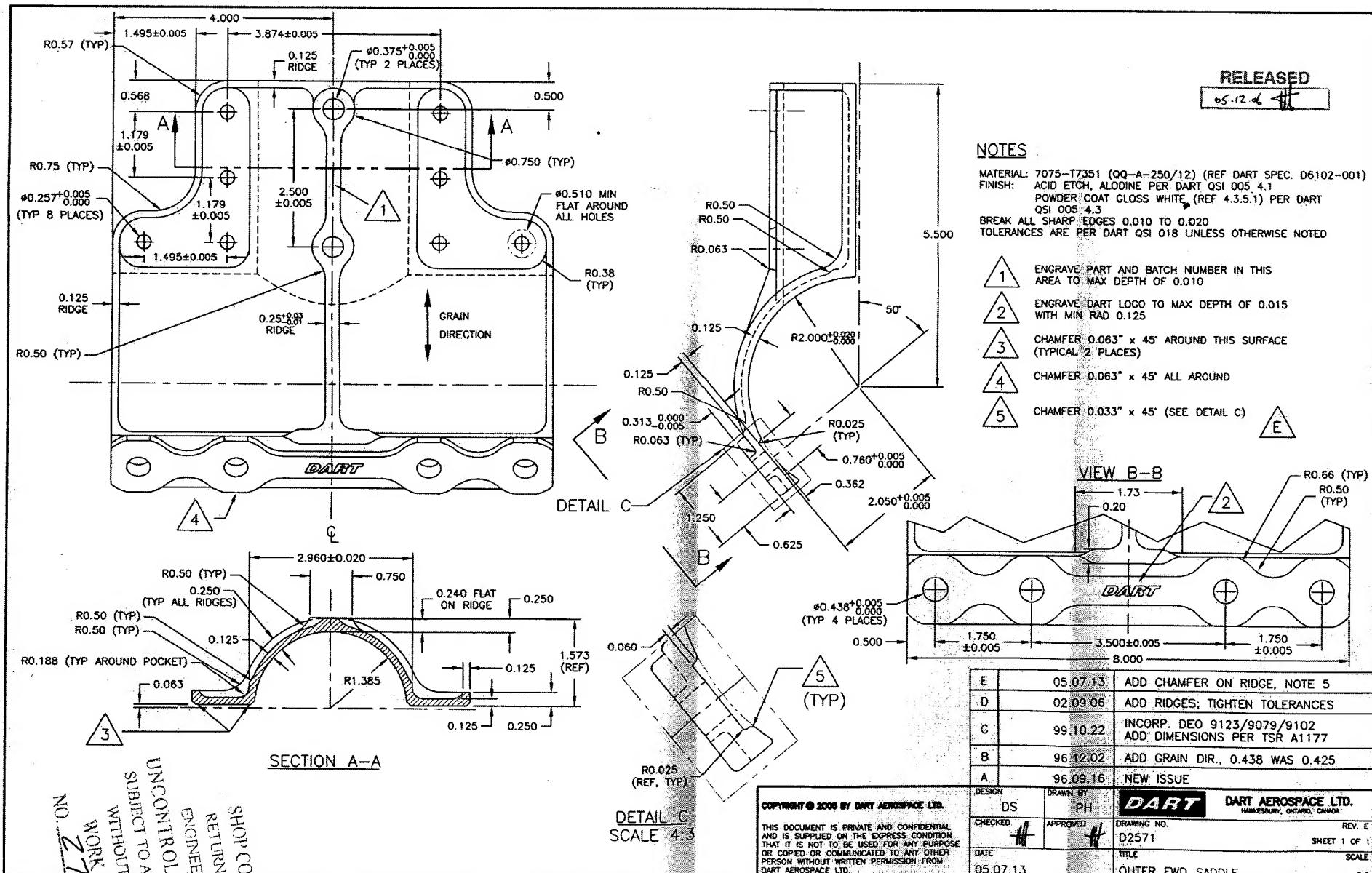
DART AEROSPACE LTD				Work Order:	27992
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 <sup>24</sup>		
A	0.438	0.443	DT8682		—	—	—		
B	1.745	1.755		1.745	1.747	1.745	1.750		
C	3.495	3.505		3.493	3.497	3.498	3.496		
D	1.745	1.755		1.745	1.747	1.745	1.750		
E	7.990	8.010		8.002	8.002	8.003	8.002		
F	0.490	0.510		0.502	0.497	0.497	0.502		
G	0.257	0.262	DT8683	—	—	—	—		
H	0.375	0.380	DT8684	—	—	—	—		
I	0.490	0.510		0.493	0.494	0.498	0.501		
J	1.174	1.184		1.176	1.177	1.175	1.175		
K	0.558	0.578		0.561	0.565	0.563	0.565		
L	1.174	1.184		1.176	1.177	1.179	1.175		
M	1.490	1.500		1.493	1.491	1.492	1.493		
N	2.495	2.505		2.499	2.497	2.497	2.497		
O	3.869	3.879		3.870	3.869	3.870	3.873		
P	0.115	0.135		0.123	0.127	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.253	0.253	0.252		
S	0.115	0.135		0.123	0.122	0.122	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.244	0.238	0.244	0.244		
W	0.115	0.135		0.119	0.119	0.122	0.117		
X	0.308	0.313		0.310	0.310	0.309	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.369	0.367	0.365	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.626	0.626	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.245	0.248	0.246		
AE	1.375	1.395		1.389	1.390	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.250	0.246	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN	Audited by:	JL
Date:	06/08/24	Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SPJ



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